

Work Order ID 92420

February-04-14 8:05:28 AM

92420

Page 1

Item ID: D412-758-013 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Top Mounted Gps Receiver Gimbal Mount
 Start Date: 10/29/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 11/16/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 14-02-04 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-758	D								

100 DOCUMENT CONTROL 0.00
 100
 DC Memo M. R. 0.00 DAS 31 14-02-06 2x
 Document Control Photocopy bluefile & type labels per PPP D412-758-013 CHG002 9-89

110 Pick Kit 0.00
 110
 Packaging Memo 0.00 2x DAS 31 14-02-4 1x
 Packaging

115 QC4- 100% Inspect kits for completeness 0.00
 115
 QC Memo 0.00 DAS 31 14-02-06 2x
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge		
☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Work Order ID 92420

92420

Page 2

February-04-14 8:05:28 AM

Item ID: D412-758-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Top Mounted Gps Receiver Gimbal Mount

Start Date: 10/29/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120						2	14-2-4		DAS
Packaging	Memo	0.00							6
Packaging	Identify and pack for shipping as per PPP D412-758-013								9-89
	Location: <u>032</u>								
	PPP Rev: <u>B</u>								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

14-02-06

14-02-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Equip/Tooling									
Handling/Pre									
Material									
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Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Training									
Transport									
Unapproved									

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Picklist Print

February-04-14 8:05:54 AM

Page 2

Work Order ID: 92420

92420

Parent Item: D412-758-013

D412-758-013

Parent Item Name: Top Mounted Gps Receiver Gimbal Mount

Start Date: 10/29/12

Required Date: 11/16/12

Start Qty: 2.00

Required Qty: 2.00

D3645-1 Manufactured No 110 Each 51.0000

D3645-1

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

ST060

51

95256

51

110

Each

181.0000

**

DAS
28
9-89

14-02-4

AN525-10R10 Purchased No 110 Each 181.0000

AN525-10R10

Screw

DAS
31
9-89

Location

Loc Qty

Loc Code

ST344

181

M126175

181

110

Each

2,886.000

**

DAS
28
9-89

NAS1149D0363J Purchased No 110 Each 2,886.000

NAS1149D0363J

Washer

DAS
31
9-89

Location

Loc Qty

Loc Code

GA

78

124392

78

ST510a

2808

m126319

1616

m127813

1192

110

Each

212.0000

**

DAS
28
9-89

MS24693-S27 Purchased No 110 Each 212.0000

MS24693-S27

SCREW

DAS
31
9-89

Location

Loc Qty

Loc Code

ST301

212

114037

212

February-04-14 8:05:54 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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5.0 PARTS LIST

QTY -011	QTY -013	QTY -015	Part Number	Description
X			D412-758-011	Bottom Mounted GPS Receiver Gimbal Mount
	X		D412-758-013	Top Mounted GPS Receiver Gimbal Mount
		X	D412-758-015	GPSMAP Top Mounted GPS Receiver Gimbal Mount
1			D3514-041	Bottom Mounted Gimbal Assembly
	1		D3514-043	Top Mounted Gimbal Assembly
		1	D3531-041	Bracket Assy.
	2	2	D2464-0066	Neoprene Seal
1	1	1	D3525-1	Placard
1			D3527-1	Support Arm
1			D3530-1	Base Plate
1			D3530-3	Mounting Plate
1	1		D3534-1	Doubler
	4	4	D3645-1	Washer
		3	AN525-10R9	Screw
	4	4	AN525-10R10	Screw
3			AN526-632R7	Screw (or MS35206-229)
3		4	NAS1149DN632J	Washer (Alternate p/n AN960JD6)
2	4	7	NAS1149D0363J	Washer (Alternate p/n AN960JD10)
3		4	MS21042L06	Nut
1		3	MS21042L3	Nut
4	4		MS24693-S27	Screw
1			MS27039-1-09	Screw
		4	MS24693-S29	Screw
		2	RAM-B-201U-A	Socket Arm, 1.75"
		2	RAM-B-202U	Round Plate Mount, Single 1" Ball
		1	RAM-B-217U	Round Plate Mount, Dual 1" Ball

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Revision: D

Date: 12.08.10

Work Order ID 92420

February-04-14 8:05:28 AM

92420

Page 1

Item ID: D412-758-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Top Mounted Gps Receiver Gimbal Mount

Stop

NS2

Start Date: 10/29/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 1402-04

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D412-758

D

100

0.00

100

DOCUMENT CONTROL

DC

Memo M. R.

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-758-013 CHG002

ML5 1402-04

2

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2x DAS
28
339

14-02-4

115

QC4- 100% Inspect kits for completeness

0.00

115

QC

Memo

0.00

Quality Control